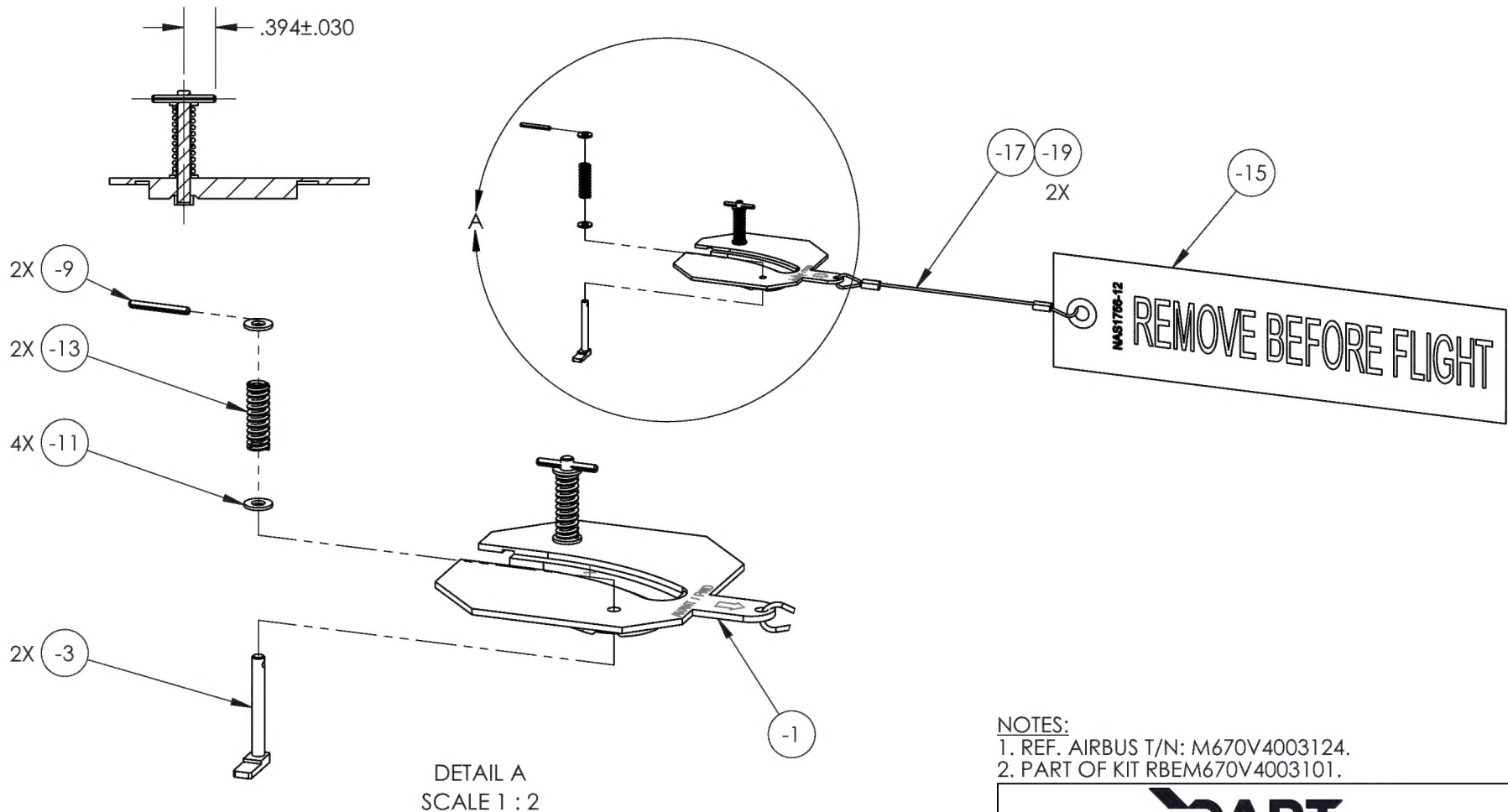


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	11/4/2016	DPD	JAG

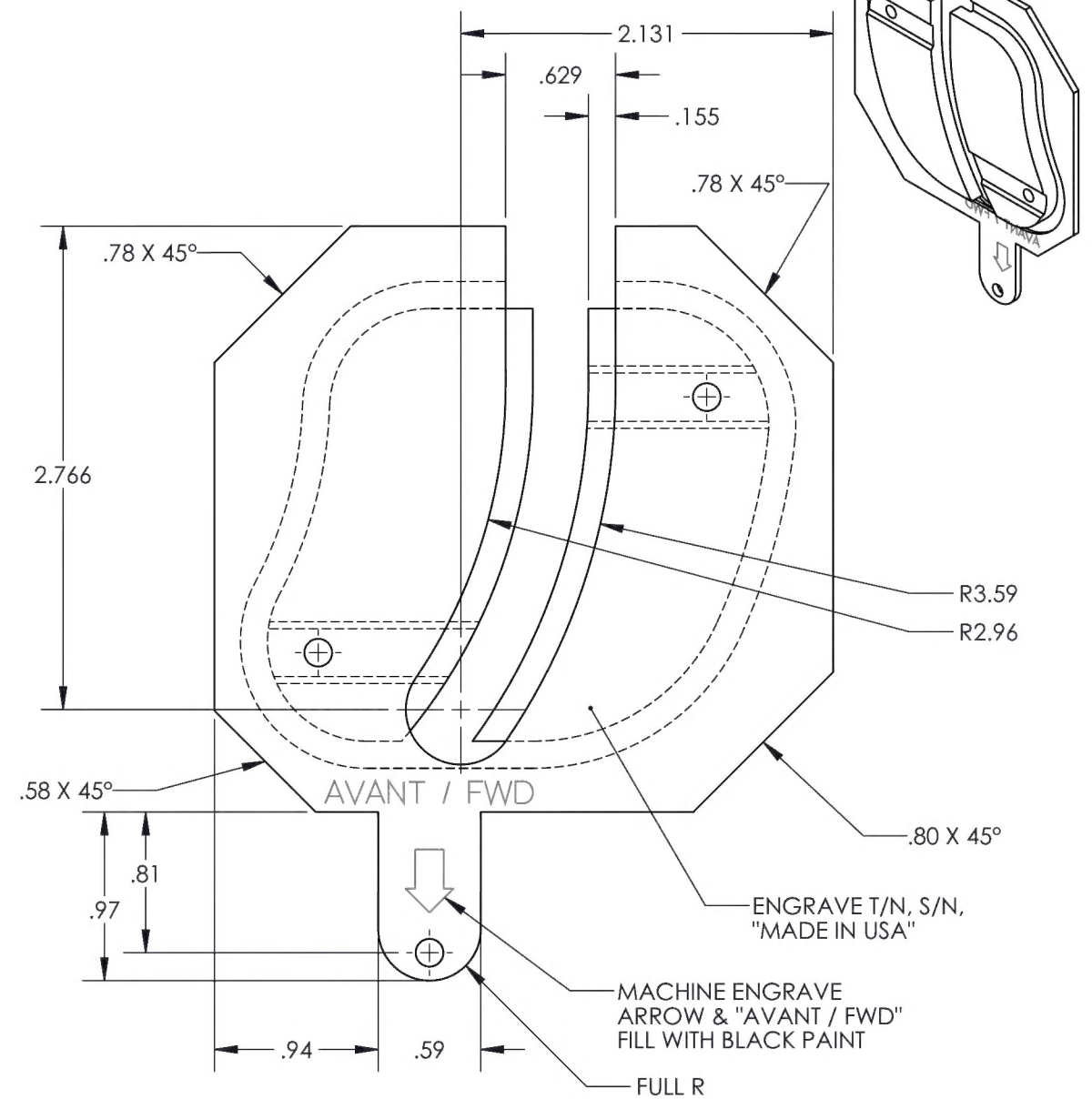


- NOTES:
 1. REF. AIRBUS T/N: M670V4003124.
 2. PART OF KIT RBEM670V4003101.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PLATE	A36/1018/1020 HR		2
	X		-3	2	PIN PLATE WELDMENT			3
	1		-5		PIN PLATE	1018/1020 CR		4
	1		-7		DOWEL PIN	O1		5
		B/O	-9	2	SPRING PIN	S.S.	M2 X 20mm (MCMASTER-CARR #91610A210)	1
		B/O	-11	4	FLAT WASHER	STEEL	M4 (MCMASTER-CARR #91166A230)	1
		B/O	-13	2	COMPRESSION SPRING	STAINLESS STEEL	Ø.050 WIRE X Ø.281 O.D. X Ø.181 I.D., 63LBS/IN (CENTURY SPRING #S-998)	1
		B/O	-15	1	REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	1
		B/O	-17	1	LANYARD	COATED STEEL	Ø1/16 X 6 (CARR LANE #CL-2-C)	1
		B/O	-19	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1
	ASSY -3							

		TITLE	
		ROLL STOP	
DWG NO.		RBEM670V4003124	
REV		1	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		DUERFELDT	
CHECKED:		CLOUGH	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:4	
DATE		5/20/2016	
SHEET		1 OF 5	

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



ROLL STOP

RBEM670V4003124-1

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
XX ± .005 FRACTIONS ± 1/8
X ± .01 ANGLES ± 5°
K ± .1 SURFACES = 125/

DIMENSIONS ARE IN INCHES
XXX ± .005 FRACTIONS ± 1/8

.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± .5°

.X	$\pm .1$	SURFACES = 125
----	----------	----------------

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

	USED ON MODEL
	1177

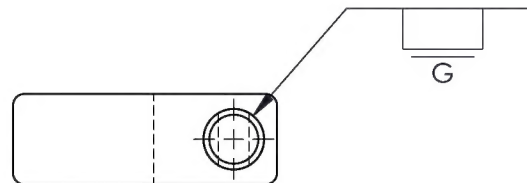
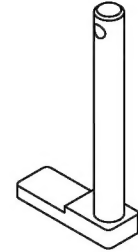
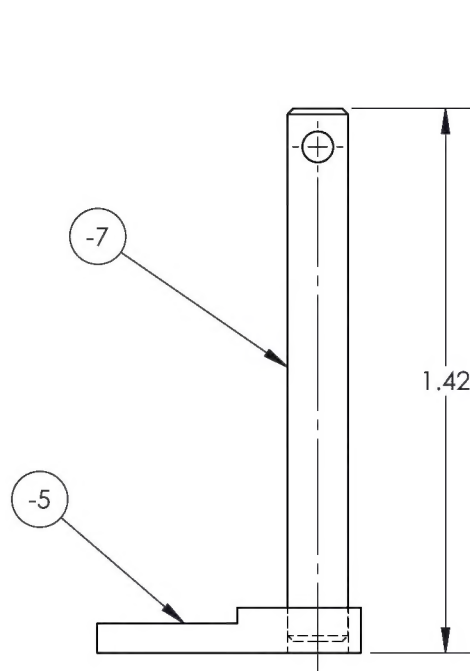
	H175
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20/2016 SHEET 2 OF 5

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



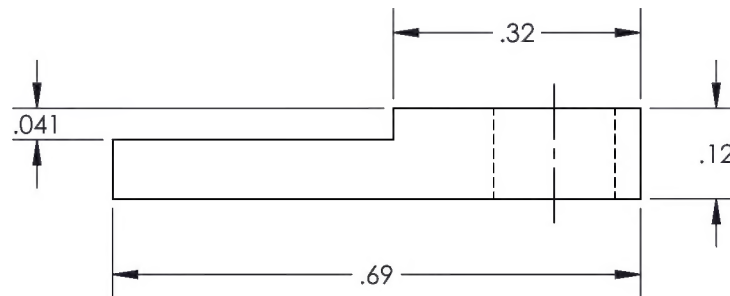
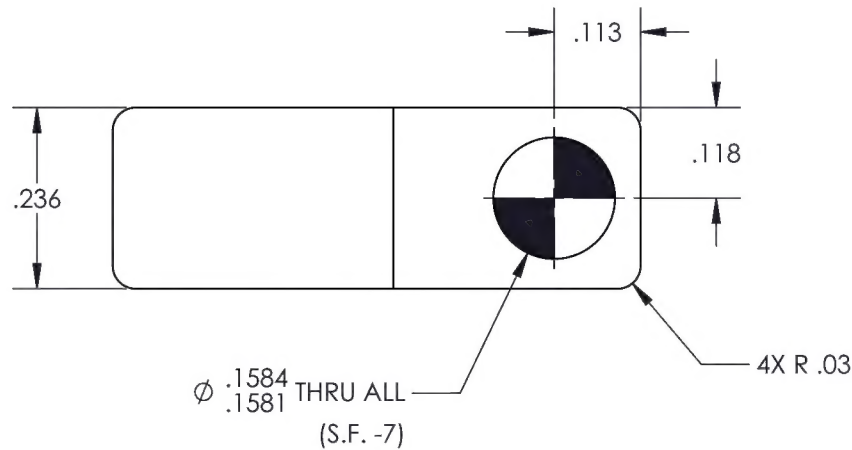
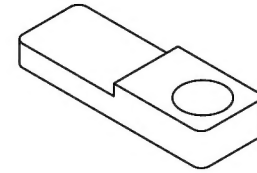
(-3)

PIN PLATE WELDMENT

DART AEROSPACE	
TITLE ROLL STOP	
DWG NO. RBEM670V4003124-3	REV 1
MAT'L HEAT TREAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 2:1	DATE 5/20/2016
SHEET 3 OF 5	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



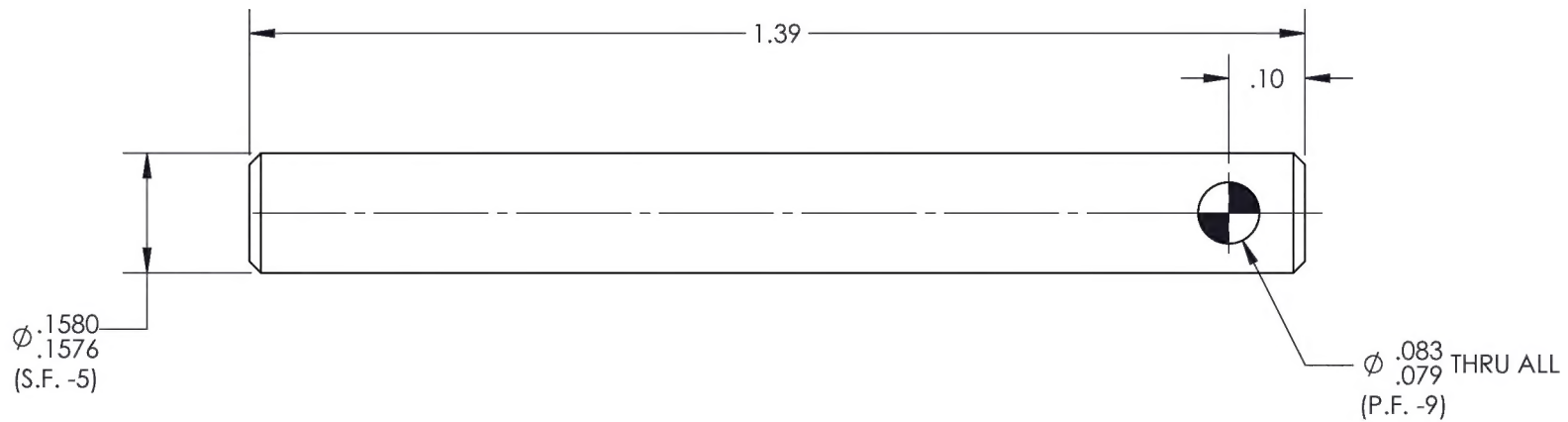
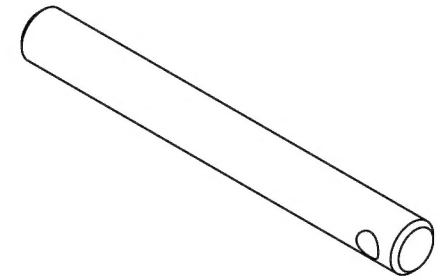
(-5)

PIN PLATE

DART AEROSPACE	
TITLE PITCH STOP	
DWG NO. RBEM670V4003124-5	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -3	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 4:1	DATE 5/20/2016
	SHEET 4 OF 5

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



(-7)
DOWEL PIN

DART AEROSPACE	
TITLE ROLL STOP	
DWG NO. RBEM670V4003124-7	REV 1
MAT'L O1 RC 50-55 TREAT SEE -3 FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL H175	
SCALE 4:1	DATE 5/20/2016
SHEET 5 OF 5	